Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C250-100
Job Sheet 177405

Part No: C250-100 **Job Qty:** 3 ea
Part Name: Side Plate Cover

Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 5/10/18 **Job Tracking No:**
Due Date: 5/18/18 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**

Note: DWG C250-100 REV:4 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Standard Run Hrs	Workcenter/Supplier Workcenter / Supplier	Lead Time	Sign-off
90	**Start up Operation**	3 Ea		5/18/18	0.00	0.00	Start Up Machining		J.C.L.
110	**Mori Seiki**	3 pcs		5/18/18	0.00	3.00	MORI NV5000-1		J.C.L.
120	**QC**	3 pcs		5/18/18	0.00	0.00	QC2		J.C.L. 18-05-20
130	**QC**	3 pcs		5/18/18	0.00	0.00	QC8		[illegible] 18/05/24
150	**Outsource**	3 pcs		5/18/18			GRO002-VC		CT18-5-24 AT 18/05/04
160	**Packaging**	3 pcs		5/18/18	0.00	0.00	Packaging2		AT 18/06/04
170	**QC**	3 pcs		5/18/18	0.00	0.00	QC6		DAS 36 9-89
175	**Small Fab**	3 pcs		5/18/18	0.00	0.75	Small Fab-1 N/A		
180	**QC**	3 pcs		5/18/18	0.00	0.00	QC5 N/A		
185	**Packaging**	3 pcs		5/18/18	0.00	0.00	Packaging3		[illegible]
190	**QC21-SA**	3 Ea		5/18/18	0.00	0.00	QC21		DAS 21 9-89 AUG 20 2018 GA166

Part Op **110** - 1-Machine as per folio FB_____ FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: **120** - Engrave S/N Using Marktronic engraver. See note 1 for location.
ALTECH **150** - -Issue P/O to ~~ATG~~: P0039965 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required
175 - -Laser Etch, white as per dwg.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.250X13.500	6061-T6 Sheet 2.250" Thick x 13.500" Wide cut to size: 16.750"	4.1400 ft (1.38 ea)	90-Start up Operation	S006897

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S2.250X13.500	4	9	0

Part Specifications

Specifications could not be found.

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S072741
Part: C250-100
Job No: 177405
Serial No/Batch: S072741
Revision:
Inspector:

Date: 05/20/18

Plex 5/10/18 11:53 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	177405
Description: Side Plate Cover		Part Number:	C250-100
Inspection Dwg: C250	Rev: 4		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.689	+0.000 -0.002	0.689	✓		T.G.	
-9.717	+/-0.005	9.717	✓		NV-5000-1	
2.207	+/-0.005	2.207	✓			
⌴ 0.915	+0.010 -0.001	0.915	✓		Caliper	JCL-08
↧ 1.155	+0.003 -0.006	1.155	✓			
↧ 0.085	+0.008 -0.005	0.086	✓			
Ø 0.750	0.008 -0.001	0.756	✓			
-9.055	+/-0.005	-9.055	✓			
5.274	+/-0.005	5.273	✓			
Ø 0.156	+0.005 -0.001	0.156	✓			
Ø 0.323	+0.006 -0.001	0.324	✓			
↧ 1.125	+/-0.005	1.122	✓			
-8.600	+/-0.005	-8.600	✓		NV-5000-1	
6.656	+/-0.005	6.656	✓			
Ø 0.9358	+0.0005 -0.0000	0.9357	✓		T.G	
⌴ Ø 1.290	+0.002 -0.004	1.290	✓			
↧ 1.145	+0.008 -0.000	1.146	✓			
-6.763	+/-0.005	-6.763	✓		NV-5000-1	
4.721	+/-0.005	4.722	✓			
Ø 0.500	+0.006 -0.001	0.504	✓		caliper	JCL-08
-3.712	+/-0.005	-3.714	✓			
4.709	+/-0.005	4.711	✓			
10-32 UNF	2B	O.K.	✓		GO-NOGO	
Ø 0.201	+0.006 -0.001	0.201	✓			
↧ 0.625	+/-0.005	0.627	✓			
Ø 1.001	+0.000 -0.001	1.001	✓		T.G.	
⌴ Ø 1.165	+/-0.012 -0.001	1.165	✓			
↧ 1.145	+0.003 -0.000	1.146	✓		Caliper	JCL-08
-1.111	+/-0.005	-1.111	✓			

Measured by:	J.C.	Checked by:		QC Inspector:	
Date:	18-05-19	Date:	18/05/24	Date:	

Engineering Approval: (If necessary)		Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No.	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval

Description Work Order Deviation	Disposition	
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment	☐	☐	No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
Design	☐	☐	Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
Doc/Data	☐	☐	Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
Equip/Tooling	☐	☐	Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
Handling/Pre	☐	☐	Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Material	☐	☐	Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
Internal Transport	☐	☐	Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
Tribal Knowledge	☐	☐	Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
LOA	☐	☐	Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
Substation	☐	☐	Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
Past Expiry Date	☐	☐	Manufacturing Process				
Misidentified	☐	☐	Past Due	☐ OTHER :			

DART AEROSPACE LTD	Work Order:	177405
Description: Side plate cover	Part Number:	C250-100
Inspection Dwg: C250 Rev: 4		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.831	+/-0.005	1.831	✓			
Ø1.501	+0.000 -0.001	1.500	✓		T.G.	
⌴ Ø1.728	+/-0.001	1.728	✓		Caliper	JCL-08
↧ 1.145	+0.003 -0.000	1.146	✓			
Ø0.6244	+0.0004 -0.0000	0.6248	✓		T.G.	
-0.081	+/-0.005	-0.081	✓			
5.980	+/-0.005	5.980	✓			
2.020	+/-0.005	2.018	✓			
1.060	+0.004 -0.000	1.060	✓			
1.188	+0.004 -0.000	1.190	✓			

Measured by:	JC.L.	Checked by:	[illegible]	QC Inspector:	
Date:	18-05-24	Date:	18/05/24	Date:	

Engineering Approval: (If necessary)		Date:	

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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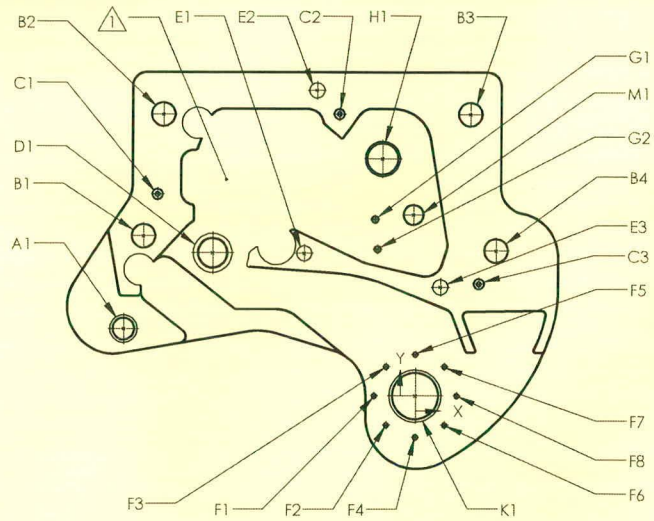
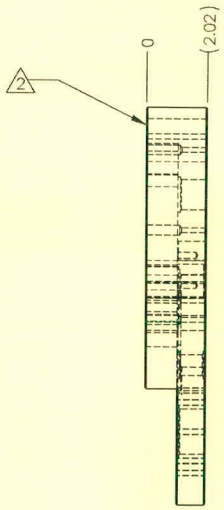
TAG	X LOC	Y LOC	SIZE
A1	-9.717	2.207	Ø .689 +.000 -.002 THRU ALL 2X .03 X 45° ⌴ Ø .915 ↧ 1.155 +.003 -.000 ⌴ Ø.915 ↧ .085 FAR SIDE
B1	-9.055	5.274	Ø.750 THRU ALL 2X .03 X 45°
B2	-8.407	9.299	
B3	1.793	9.299	
B4	2.659	4.796	
C1	-8.600	6.656	Ø.156 THRU Ø.323 ↧ 1.125 .02 X 45° NEARSIDE
C2	-2.560	9.310	
C3	2.088	3.700	
D1	-6.763	4.721	Ø .9363 .9358 THRU ALL .04 X 45° NEARSIDE ⌴ Ø 1.290 ↧ 1.145 +.003 -.000
E1	-3.712	4.709	Ø .500 THRU ALL
E2	-3.307	10.093	
E3	.817	3.592	
F1	-1.368	.000	10-32 UNF THRU ALL
F2	-.967	-.967	
F3	-.967	.967	
F4	.000	-1.368	
F5	.000	1.368	
F6	.967	-.967	
F7	.967	.967	
F8	1.368	-.000	
G1	-1.356	5.828	Ø.201 ↧ .625 .02 X 45°
G2	-1.269	4.843	
H1	-1.111	7.831	Ø 1.001 +.000 -.001 THRU ALL .03 X 45° NEARSIDE .04 X 45° FARSIDE ⌴ Ø 1.165 ↧ 1.145 +.003 -.000
K1	.000	.000	Ø 1.501 +.000 -.001 THRU ALL .03 X 45° NEARSIDE ⌴ Ø 1.728 ↧ 1.145 +.003 -.000
M1	-.081	5.980	Ø .6248 .6244 THRU ALL .03 X 45° NEARSIDE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 177405 MLS 18-05-10

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
		AS DRAWN BY APICAL.	6/12/2013	CFS	
1		CH'D M1 HOLE TOLERANCE WAS Ø.627 +.000 -.001 IS Ø.6248-.6244.	6/28/2013	CFS	JAG
2		CH'D M1 HOLE CHAMFER WAS .03 X 15° IS .03 X 45°.	8/20/2013	CFS	JAG
3	14-0128	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D DIMS WAS (16.360) IS 16.36, WAS (13.151) IS 13.15. ADDED DXF NOTE.	8/14/2014	DPD	RW
4	15-0309	ADDED HOLE ↧ NOTE. DELETED CAUTION NOTE ENGRAVING. DELETED DIMS 7.27, Ø1.03, 4.64, Ø1.28, 9.19, Ø1.03, 4.17, 4.98, 9.01. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	9/18/2015	DPD	JAG





NOTE:
1. MACHINE ENGRAVE BATCH NUMBER.
2. HOLE ↧ CALLED FROM THIS SURFACE.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C250-100	1	SIDE PLATE COVER	6061	

DART AEROSPACE

TITLE: SIDE PLATE COVER

DWG NO. C250-100 REV 4

MAT'L 6061 — DRAWN BY: APICAL

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/8
ANGLES ±.5°

APPROVED D Weil

HEAT TREAT

FINISH: BLACK ANODIZE

SPEC: MIL-A-8625, TYPE II, CLASS II

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

USED ON MODEL

SCALE 1:4 — DATE 6/13/2011 — SHEET 1 OF 2

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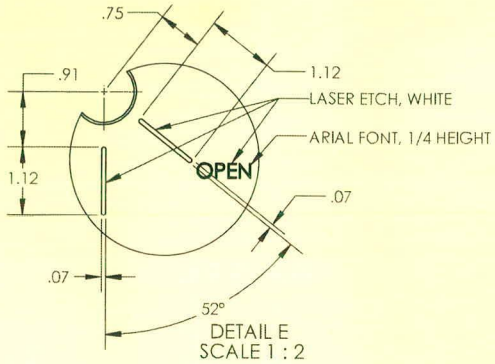
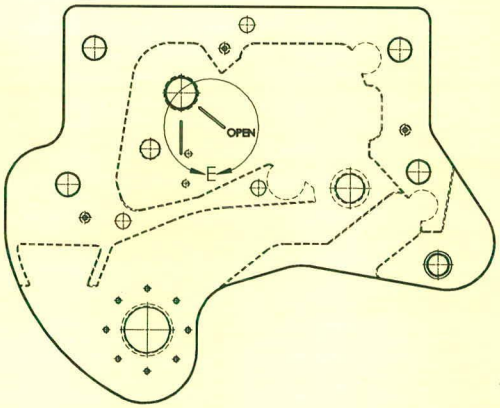
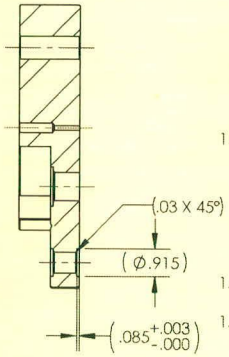
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D M1 HOLE TOLERANCE WAS Ø.627 +.000 -.001 IS Ø.6248-.6244.	6/28/2013	CFS	JAG
2		CH'D M1 HOLE CHAMFER WAS .03 X 15° IS .03 X 45°.	8/20/2013	CFS	JAG
3	14-0128	CH'D DIMS WAS (16.360) IS 16.36, WAS (13.151) IS 13.15. ADDED DXF NOTE.	8/14/2014	DPD	RW
4	15-0309	DELETED CAUTION NOTE ENGRAVING. DELETED DIMS 7.27, Ø1.03, 4.64, Ø1.28, 9.19, Ø1.03, 4.17, 4.98, 9.01.	9/18/2015	DPD	JAG

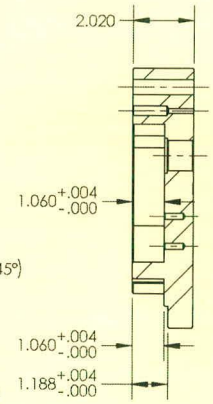


DETAIL E
SCALE 1 : 2

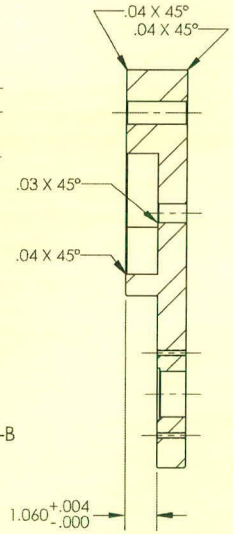




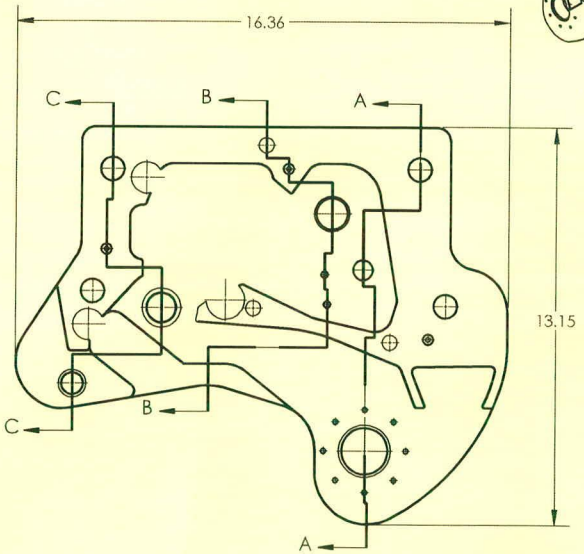
SECTION C-C

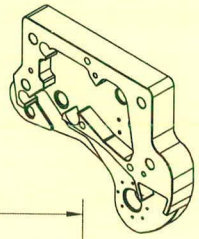


SECTION B-B



SECTION A-A





NOTE:
USE DXF PROFILE FOR POCKET DETAILS.

DART AEROSPACE

TITLE	SIDE PLATE COVER		
DWG NO.	C250-100		REV 4
MAT'L 6061		DRAWN BY:	APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ±.5°		APPROVED	D Weil
		HEAT TREAT	
		FINISH	BLACK ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		SPEC	MIL-A-8625, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE 1:4	DATE 6/13/2011	SHEET 2 OF 2	

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO039965

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039965
PO Date: 5/23/18
Due Date: 5/31/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: CT.

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173867	RBE350A93-3500-00-1	Body -Issue P/O to Groupe Altech: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	5/31/18	12 pcs	0 pcs 12x	12 pcs	$15.5263157/pcs AT 18/06/04	$186.32
3	177272	RBW6305G11331-3G-13	Socket -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	5/31/18	1 pcs	0 pcs 1x	1 pcs	$95.526315/pcs AT 18/05/31	$95.53
4	177405	C250-100	Side Plate Cover -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	5/31/18	3 pcs	0 pcs 3x	3 pcs	$64.026315/pcs AT 18/06/04	$192.08
5	177406	C250-200	Side Plate Housing -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	5/31/18	3 pcs	0 pcs 3x	3 pcs	$76.52631/pcs AT 18/06/04	$229.58

Grand Total: $703.50

GROUPE altech POLISSAGE & PLACAGE

Certificat de Conformité / Certificate of Compliance

(009663-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

009663 - 3

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition / Ship date	Créé Par / Generated By	Transport / No de Compte / Courrier / Acc. No.	Bon de commande Client / Customer Purchase Order No.
01-Jun-2018	Aman		PO039965

#Ligne Line#	No. de Série / # Pièce / Part Number /Line Item Details / Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities: Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3500-00-1 Rev.	RBE350A93-3500-00-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	12	12	0	0	0
4	C250-100 Rev.	C250-100 01 -ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0
5	C250-200 Rev.	C250-200 01 -ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0

Notes Additionneles / Additional Notes

Epaisseur réele
Actual Thickness

Inspecteur Qualité
Quality Inspector

Récu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les éxigeances.
Notre résponsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsability will not be higher than the amount of invoice.

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